

ABSTRACT

A work chucking/inserting apparatus 60 to be used for chucking a work (piston 62) and inserting the work into an insertion hole (cylinder bore) in alignment with the hole, including three or more chuck fingers 65, the chuck fingers 65 being arranged in circumferentially spaced positions and capable of advancing and retreating radially, inner surfaces of the chuck fingers 65 serving as chuck surfaces for chucking the work, and outer surfaces of the chuck fingers 65 being tapered at least at tip end portions thereof so that the closer to the tips, the more inwards the taper, and capable of coming into contact with an inlet of the insertion hole. The work chucking/inserting apparatus 60 further includes a tracer mechanism which causes the axis of a conical surface defined by the outer surfaces of the chuck fingers 65 to be aligned with the axis of the insertion hole when the outer surfaces of the chuck fingers 65 are put in contact with the inlet of the insertion hole, and a pushing mechanism for pushing the work toward the insertion hole. The work chucking/inserting apparatus can handles various sizes of works with a simple structure and that in a short time and a high working efficiency.